

## (12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
20 March 2003 (20.03.2003)

PCT

(10) International Publication Number  
**WO 03/022471 A1**

(51) International Patent Classification<sup>7</sup>: **B21B 31/08**,  
31/07, F16C 13/02, 35/06

(21) International Application Number: PCT/EP02/09785

(22) International Filing Date:  
2 September 2002 (02.09.2002)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
MI2001A001859 4 September 2001 (04.09.2001) IT

(71) Applicant (for all designated States except US): **DANIELI & C. OFFICINE MECCANICHE S.P.A.** [IT/IT]; Via Nazionale, 41, I-33042 Buttrio (IT).

(72) Inventor; and

(75) Inventor/Applicant (for US only): **DI GIACOMO, Marco** [IT/IT]; Vicolo Fornaci, 10, I-34071 Cormons (IT).

(74) Agent: **GERVASI, Gemma**; Notarbartolo & Gervasi, Corso di Porta Vittoria, 9, I-20122 Milan (IT).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZM, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

## Declaration under Rule 4.17:

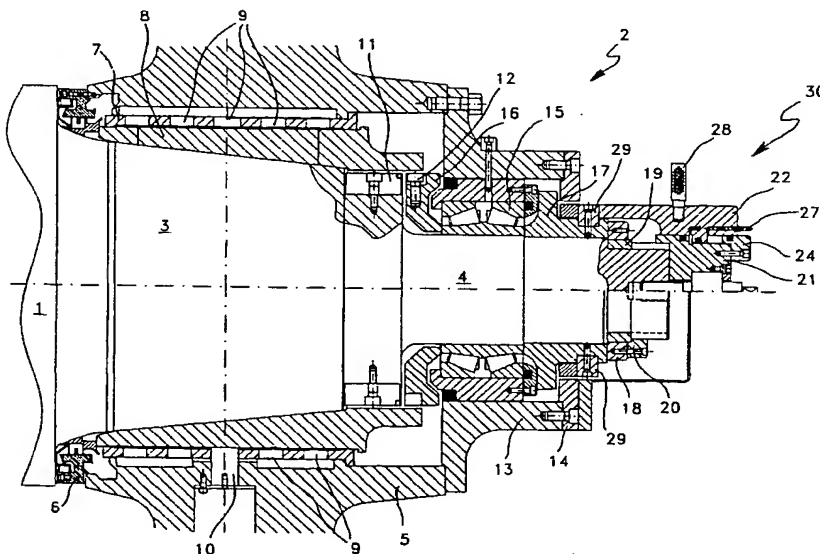
— of inventorship (Rule 4.17(iv)) for US only

## Published:

— with international search report

[Continued on next page]

(54) Title: HYDRAULIC FAST LOCKING AND LOOSENING DEVICE FOR BEARING ASSEMBLIES OF ROLLING-MILL CYLINDERS, AND CORRESPONDING METHOD OF USE



(57) Abstract: A hydraulic locking and loosening device (40) is set on the neck of a rolling-mill roll or back-up roll with a conical part (3) and a cylindrical part (4), and comprising an oil-film bearing (7, 8), a spacer ring (16), a thrust bearing (15), a thrust ring (17), and a threaded lock ring (18). The locking device (30) comprises a body (21) inserted at the centre in a ram (22) to form a hydraulic actuator with two annular chambers (23), longitudinal arms (31), on each of which is provided a C-shaped notch (32), and a cover (24) for closing the hydraulic chambers (23). A variant of the hydraulic locking and loosening device (40) is provided with a bayonet device for its engaging on the roll end.

WO 03/022471 A1



- *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments* . *For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

## Hydraulic fast locking and loosening device for bearing assemblies of rolling-mill cylinders, and corresponding method of use

### Field of the invention

The present invention relates to a hydraulic fast locking and loosening device, which can be temporarily mounted on bearing assemblies that support in rotation the necks of rolls of rolling-mill, for tightening and loosening the chock of the roll neck, as well as to a method for use of said device.

### State of the art

In roll stands, and more in particular in back-up rolls, it is common practice to utilise hydraulically actuated or screw-actuated devices for axially locking rolling mill bearing assemblies in their positions on the roll necks.

In known rolling mills, such locking devices are designed as integral parts of the bearing assemblies, thereby increasing considerably the cost of said assemblies.

A further drawback of screw actuated locking devices is that they are difficult to tighten, frequently requiring the use of cables pulled by means of overhead cranes. This process increases the risks of injury for the maintenance staff and possible damage to the equipment.

Another known technique is to use hydraulically actuated portable tools that can be temporarily mounted on the bearing assemblies of the rolling mills. however, such tools are designed for tightening the bearing assemblies on the roll necks, and are not useful for loosening said bearing assemblies. Thus, disassembly is carried out with other means, which in all cases comprise the use of overhead cranes and/or of other hydraulically or mechanically operated means.

### Summary of the invention

Consequently, the purpose of the present invention is to overcome the problems discussed above of known state-of-the-art fast locking and loosening devices, by providing a hydraulic locking and loosening device adapted for locking and loosening bearing assemblies on roll necks of rolling mills, which is easy to  
5 operate and saves both time and work during use.

Another purpose of the present invention is to provide a hydraulic locking and loosening device which ensures economy of operation, reduces maintenance, and enables an inexpensive conversion of previous more complex mechanical and hydraulic locking systems.

10 Another purpose of the invention is to provide a hydraulic locking and loosening device designed to operate on roll ends with end sections that are shorter and of a simpler structure.

It is also an object of the present invention the provision of a hydraulic device for locking and loosening of bearing assemblies which is reliable and compact.

15 The above purposes are achieved by a hydraulic locking and loosening device having the features of Claim 5. The inventive configuration of the device comprises a smaller number of components and can be associated to a roll bearing assembly of a particularly simple structure. The reduction in costs that derives therefrom for rolling-mill plants is consequently substantial. The structural simplicity of the device  
20 renders it easy to use and repair. Since it is easy to remove from its seat on the mill bearing assembly, one hydraulic locking and loosening device can be used on a plurality of roll stands.

According to a particular aspect of the present invention, there is moreover provided a method for the use of the hydraulic locking and loosening device for roll bearing assemblies, the said method having the features specified in Claim 11.

According to yet another particular aspect of the present invention, there is also  
5 provided a hydraulic locking and loosening device for roll bearing assemblies having the features specified in Claim 1.

The proposed bearing assembly has a simplified structure and can replace other bearing assemblies of a more complex structure. It is structurally faster and simpler to build and moreover involves a chock end plate for the reinforcement  
10 that is of a simpler form, as well as a cover that is also simpler.

#### Brief description of the figures

Further characteristics and advantages of the invention will become more apparent in the light of the ensuing detailed description of preferred, but not  
15 limitative, embodiments of a hydraulic device for locking and loosening of bearing assemblies of roll stands and of the corresponding method of use, illustrated by way of non-limiting example by means of the accompanying drawings, in which:

Fig. 1 shows a partial longitudinal sectional view of a bearing assembly on which a hydraulic locking and loosening device according to the invention is employed;

Fig. 2 shows a side view of the hydraulic locking and loosening device of the  
20 invention;

Fig. 3 shows a view from the rear of the device of Fig. 2;

Fig. 4 shows a front view of the device of Fig. 2;

Fig. 5 shows a sectional view of the device illustrated in Fig. 2, mounted on a bearing assembly in operation;

Fig. 6 shows a side view of the device of Fig. 2 installed on a bearing assembly in operation;

Fig. 7 shows a longitudinal section of another embodiment of a hydraulic locking and loosening device according to the invention, installed on a corresponding

5 bearing assembly in operation,

Fig. 8 represents a section, along the line A-A, of the device of Fig. 7; and

Fig. 9 represents a side view of the hydraulic device of Fig. 7.

#### Detailed description of preferred embodiments of the invention

With reference to Figure 1, the end of the roll 1, in particular of a back-up roll, is  
10 represented, with a hydraulic locking and loosening device according to the present invention, globally indicated by the reference numeral 2. The roll end portion has a first tapered part 3, advantageously of a conical shape, and a second cylindrical part 4, both parts being supported in rotation in a housing of the frame 5 of the roll mill. On the side of the roll of larger diameter, there is provided a  
15 seal 6 to retain oil of the oil-film bearing. The latter comprises a bushing 7 made of white metal alloy and a sleeve 8 with tapered inner surface to adapt to the tapered portion 3 of the roll. The bushing 7 is provided with apertures for oil feed 9 and is fixed on the frame 5 by means of lock pins 10, whilst the sleeve is in turn fixed, in order to prevent rotation, on the roll neck by means of the ring keys 11 and 12.

20 In a position corresponding to the end part of the bearing assembly there is provided chock end plate 13, which is fixed on the frame 5 by means of screws and is closed on the external side by a flange 14. Around the cylindrical part 4 of the roll neck there is fitted a thrust bearing 15, held inside a corresponding hole of the chock end plate 13. The thrust bearing 15 is held firm between a ring 16 on the

inside of the neck of the cylinder and a thrust ring 17 on the outside. The thrust ring 17 is secured to the cylindrical part 4 of the roll, to prevent axial displacement, by a threaded lock ring 18, screwed on a two-part threaded ring 19 and fastened in a groove of the cylindrical part 4. Two locking keys 20 ensure locking of the ring 18 to prevent any loosening during the operation of the roll mill.

With particular reference to a first embodiment of the invention, in the partial section above the axis of the bearing assembly, with reference to Fig. 1, the hydraulic locking and loosening device, globally designated by the reference numeral 30, is installed on the bearing assembly for carrying out the locking operation, and comprises a cylindrical body 21, surrounded by a ram 22. Both the body 21 and the ram 22 are made in such a way as to form between them two chambers of annular shape and to form a double-acting hydraulic actuator 23. A protective end cap 24 closes the hydraulic outer chamber of the actuator 23 formed in the space between the body 22 and the ram 21. The device 30 is fixed to the back-up roll body during the locking and loosening operation by means of a fixing screw 26. A quick-release coupling 27 enables connection to a hydraulic power source for actuating the device 30. The hydraulic locking device 30 is provided with two pin engagement levers 28 for facilitating twist-lock insertion on the back-up roll end. Four locking pins 29 are set on the thrust ring 17 and fix the hydraulic device 30 to the bearing assembly during operation. The device ram 22 is provided with four arms 31, each of which has a seat or notch 32 to engage the respective locking pin 29. The engaged position of the hydraulic locking and loosening device is illustrated more clearly in Figures 5 and 6.

Operation of the hydraulic device 30 is described in what follows. Whenever it is necessary to install the oil-film bearing 7, 8 and the thrust bearing 15, the various elements of the bearing assembly are fitted around the end part of the roll 1. First the bushing 7 is fitted, then the sleeve 8 and the ring 16, and next the thrust bearing 15 and the thrust ring 17. The chock end plate is closed by the flange 14, the threaded ring 19 is tightened on the roll end part and the lock ring 18 is fitted on the ring 19.

The device 30 is mounted temporarily and releasably, for carrying out the operation, on the end part of the roll 1. The device ram 22 is turned through 45° about its own axis with the aid of the levers 28 to engage, with the four arms 31, the pins 29 by means of the C-shaped seats or notches 32 for blocking the device, which is further fastened on the end of the cylinder by a screw 26, which is screwed on the end part of the cylinder. The locking device is then pressurised hydraulically by means of the actuator 23, which exerts an axial force directed towards the left in Fig. 1, forcing the thrust ring 17 against the thrust bearing 15 and pushing the entire chock and the oil-film bearing assembly against the tapered part 3 of the roll neck. The lock ring 18 is then tightened against the thrust ring 17, for example by means of a special C-shaped spanner. Two locking keys 20 are fitted in roll end key-ways and screwed to the lock ring 18.

The pressure is then removed from the assembly device 30, and the latter is then detached from the roll end, first by turning the arms 31 through an angle of 45°, and then by unscrewing the device blocking screw 26.

The process of disassembly of the chock and of the bearing assembly using the same hydraulic locking and loosening device 30 is the reverse of the operation



described above: the tool is used to pull the thrust ring 17 away from the chock end plate 14 and to loosen the sleeve 8.

With particular reference to a second embodiment of the invention, illustrated in Fig. 7 and following figures, the hydraulic locking and loosening device, globally indicated by reference numeral 40, is installed on the bearing assembly for locking operation, and comprises a cylindrical body 41 surrounded by a ram 42. The body 41 and the ram 42 are designed in such a way as to provide two chambers of an annular shape, which constitute a double-acting hydraulic actuator 43. An end cap 44 closes the external hydraulic chamber of the actuator 43 formed by the space between the body 42 and the ram 41.

The device 40 is fixed to the back-up roll body during the locking or loosening operation by a first twist-lock bayonet fast-block coupling. The first twist-lock bayonet device comprises a certain number of teeth 46 set on the body 41, which are adapted to engage in the annular groove 47 present on the end part of the roll 1. The first bayonet device is operated by aligning the teeth 46 with the splines on the roll end, axially translating the device or tool 40 until the teeth 46 are set on the annular groove 47 and turning it through a given angle, for example 45°. The tool is thus fixed to the roll end.

The hydraulic locking device 40 is provided with two levers 48', 48" used for tool control and for generating the rotary movement necessary for fixing the bayonet device on the roll end.

A second twist-lock device is provided for fitting the tool 40 on the thrust ring 57. The longitudinal splines present on the thrust ring 57 enable the teeth 52 of the end of the arms 51', 51" to translate axially and insert in the annular groove 53 of

the thrust ring 57. When the tool 40 is turned through the same pre-defined angle, as mentioned above, the device 40 comes to be fixed to the bearing assembly for carrying out the operation. The device 40 can have a different number of arms 51, for example three or four, according to the structural needs, and the number of the  
5 corresponding splines is defined accordingly.

A quick-release coupling enables coupling of the hydraulic actuator 43 to a hydraulic pump for engaging the bayonet arrangement 52, 53 to the end of the cylinder 1 when the hydraulic pressure is applied in the inner annular chamber and for disengaging when the hydraulic pressure is applied in the outer annular  
10 chamber.

A suspension arm 58 is advantageously provided for gripping the tool with a lifting device (not illustrated in the figures). This arm facilitates manipulation of the tool during operation, or else for storing.

The operation of the device 40, when it is used for the locking of the bearing, is as  
15 described in what follows. Whenever it is necessary to fix the oil-film bearing 7 and the thrust bearing 15, the various elements of the bearing assembly are fitted around the end part of the roll 1. The bushing 7 is fitted first, followed by the sleeve 8 and the ring 16, and finally by the thrust bearing 15 and the thrust ring 17. The chock end plate is closed by the flange 14, and next the ring 19 with a thread  
20 on its outer surface is shifted onto the roll end and finally the lock ring 18 is screwed onto the ring 19.

The device 40 is installed, temporarily and releasably for carrying out the operation, at the end of the roll 1. The device is then turned about its own axis through an angle of, for example, 45°, using the levers 48 for engaging the first

twist-lock bayonet device with the roll end and the second twist-lock bayonet with the thrust ring 57.

The assembly device 40 is then supplied with hydraulic fluid under pressure by means of the actuator 43, which exerts an axial force directed towards the left of Fig. 7, forcing the thrust ring 57 against the thrust bearing 15 and pushing the entire reinforcement and the oil-film bearing in close contact against the tapered part of the roll neck (not illustrated in detail in this figure). The lock ring 18 is then tightened against the thrust ring 57, for example by means of a special C-shaped spanner. If necessary, locking keys are inserted in keyways at the roll end and screwed to the lock ring 18.

The pressure is then removed from the locking device 40, and the latter is detached from the end of the cylinder by turning the bayonet devices through an angle of approximately  $45^\circ$  and then axially sliding the locking device away from the roll end.

The process for loosening and removing the chock and the bearing assembly using the same locking and loosening device 40 is the reverse of the one described above, in which the same tool is used for pulling away the thrust ring 57 from the chock end plate 14.

From what has been said above it is evident that the locking and loosening device according to the invention achieves all the objectives set above. Its design enables savings in terms of time and resources as compared with locking and loosening tools of the prior art because the device is not permanently connected to one cylinder only, and the structures of the roll end section, of the chock end plate and of the cover are simplified. Thanks to its simplified design and to the fact that it has

only a few moving parts with standard seals and connectors, the device according to the invention requires limited maintenance. It is moreover easy to use since only three main operations are necessary to tighten a bearing assembly.

## CLAIMS

1. A roll bearing assembly comprising a roll with an end neck having a first portion (3), with a tapered external surface, and a second portion (4), at the external end of the roll neck, with a cylindrical external surface and adjacent to  
5 said first portion (3), and further comprising, from the internal end to the external end of the roll neck, an oil-film bearing (7; 8) fitted on said first portion (3), a spacer ring (16), a thrust bearing (15), a thrust ring (17, 57) and a threaded lock ring (18) fitted on said second portion (4), said thrust ring (17, 57) being provided with engagement means for releasably engaging a roll bearing locking and  
10 loosening device (30, 40) for locking and loosening operations.
2. Roll bearing assembly according to Claim 1, wherein the thrust ring (17) is provided with at least two pins (29) fixed radially on its external surface to engage complementary C-shaped indentations (32) of a roll bearing locking and loosening device.
- 15 3. Roll bearing assembly according to Claim 1, wherein the thrust ring (57) is provided with an annular groove (53) to engage with complementary teeth (52) of a roll bearing locking and loosening device (40).
4. Roll bearing assembly according to Claim 1, wherein there is provided a chock end plate (13) with a housing designed to receive the external part of said thrust  
20 bearing (15).
5. Hydraulic locking and loosening device comprising a substantially cylindrical body (21, 41), a cylindrical ram (22, 42) provided with a central hole adapted to be set around said cylindrical body (21, 41) at a first ram end side, such as to form at least two annular hydraulic chambers (23, 43) in correspondence of the surface of

reciprocal contact, a cylindrical end cap (24, 44) to close at least one of said hydraulic chambers (23, 43), and at least two longitudinal arms (31, 51', 51'') extending in an axial direction towards a second ram end side, each of said longitudinal arms (31, 51', 51'') being provided with releasable engagement means  
5 to releasably engage a roll bearing assembly for locking and loosening operations.

6. Device according to Claim 5, wherein said releasable engagement means comprise a C-shaped indentation (32) on said longitudinal arms (31).

7. Hydraulic device according to Claim 6, in which the cylindrical ram (22) is provided with four longitudinal arms (31).

10 8. Hydraulic device according to Claim 7, wherein there is provided a screw (26), set axially, for fixing said device to one roll end during operation.

9. Hydraulic device according to Claim 5, wherein said releasable engagement means comprise bayonet devices (46, 47, 52, 53), of the twist-lock type.

10. Hydraulic device according to Claim 9, wherein one of said bayonet devices of  
15 the twist-lock type is set on said longitudinal arms (51', 51''), and the second is set on said cylindrical body (41).

11. A method for locking bearing assemblies of the type according to Claim 1 on a roll end by means of a hydraulic device (30, 40) according to Claim 5, comprising the following steps:

- 20 a) fitting in the following order of: a bushing (7), a tapered sleeve (8), a spacer ring (16), a thrust bearing (15), and a thrust ring (17, 57) on the neck (3, 4) of a roll (1);  
b) closing of a chock end plate (13) by means of a flange (14);  
c) fitting of a threaded ring (19) on the roll end part and of a lock ring (18) around said ring (19);

- d) assembling the hydraulic device (30, 40) around the end part of said roll (1);
- e) rotating the device (30, 40) about its own axis by an appropriate angle, to engage operatively engagement means (29, 53) located on said thrust ring (17, 57), thus locking the device (30, 40);
- 5 f) fixing of said hydraulic device (30, 40) to the end of the cylinder by actuating fixing means (26, 46, 47) on the end of the cylinder;
- g) pressurizing of the hydraulic device (30, 40) by means of an actuator (23, 43), thus exerting an axial force and forcing said thrust ring (17, 57) against said thrust bearing (15) and pushing the chock and the oil-film bearing against said roll neck
- 10 (3);
- h) tightening said lock ring (18) against the thrust ring (17, 57);
- i) releasing the pressure from said hydraulic device (30, 40);
- j) rotating the device (30, 40) by an appropriate angle; and
- k) removing said fixing means (26, 46, 47) and extracting the hydraulic device
- 15 (30, 40).

12. A method for loosening of bearing assemblies of the type according to Claim 1 from a roll end by means of a hydraulic device (30) according to Claim 5, comprising the following steps:

- a) assembling the hydraulic device (30, 40) on the end part of said roll (1);
- 20 b) rotating the device (30, 40) about its own axis through an appropriate angle, to engage operatively engagement means (29, 53) located on said thrust ring (17, 57), thus fixing the device (30, 40) to the roll end;
- c) fixing the hydraulic device (30, 40) to the roll by actuating fixing means (26, 46, 47) on the roll end;

d) loosening said lock ring (18) from the thrust ring (17, 57);

e) opening of a chock end plate (13), releasing it from a flange (14);

f) pressurising the hydraulic device (30, 40) by means of an actuator (23, 43), thus exerting an axial force and forcing said thrust ring (17, 57) away from said thrust

5 bearing (15), freeing the chock and the oil-film bearing from the pressure on said roll neck (3);

g) detaching said hydraulic device (30, 40) and said thrust ring (17) from said roll end; and

10 i) extracting, in the following order from the neck (3, 4) of the roll (1): a thrust bearing (15), a spacer ring (16), a tapered sleeve (8), and a bushing (7).



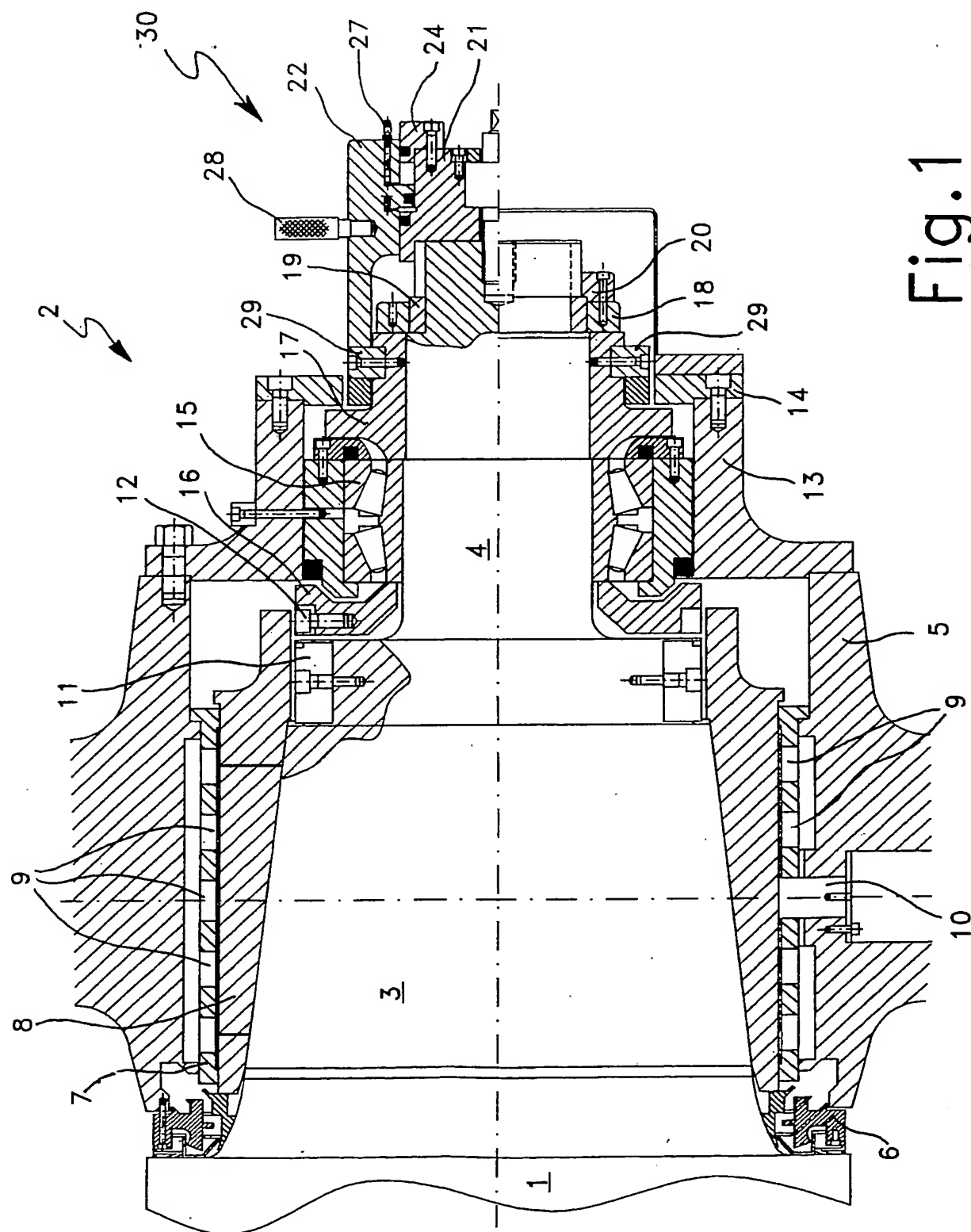


Fig. 1

Fig. 2

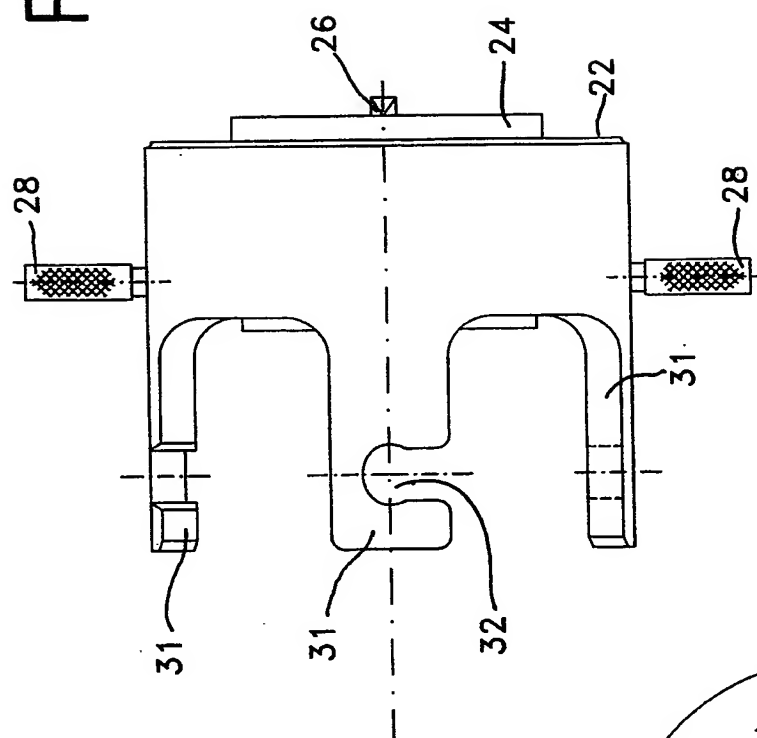


Fig. 4

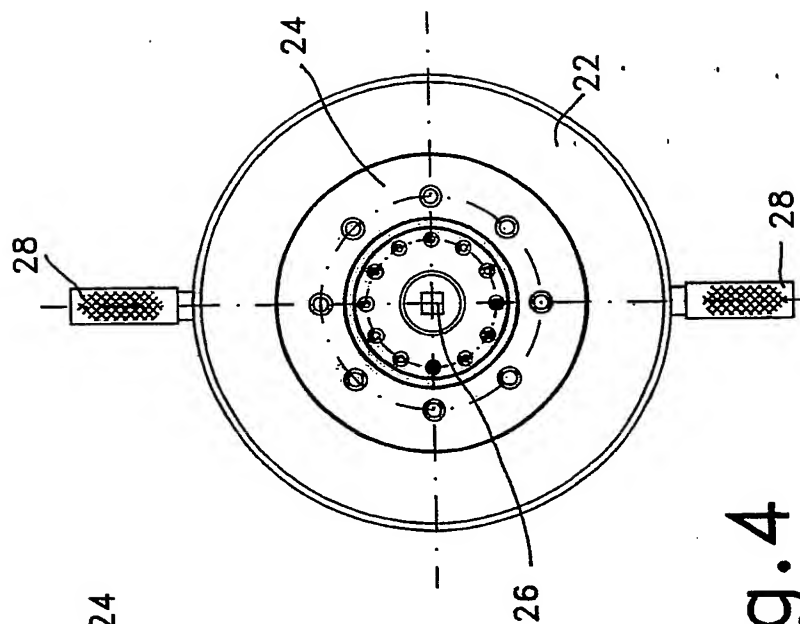
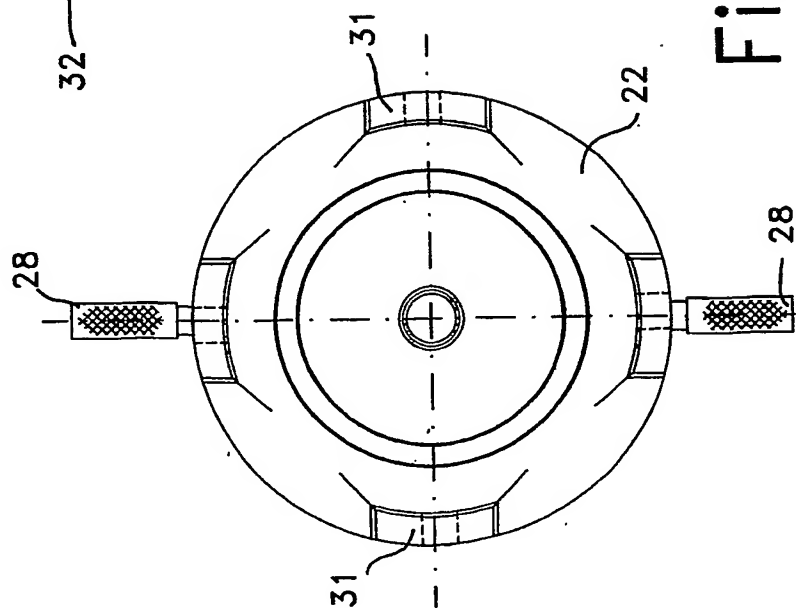


Fig. 3



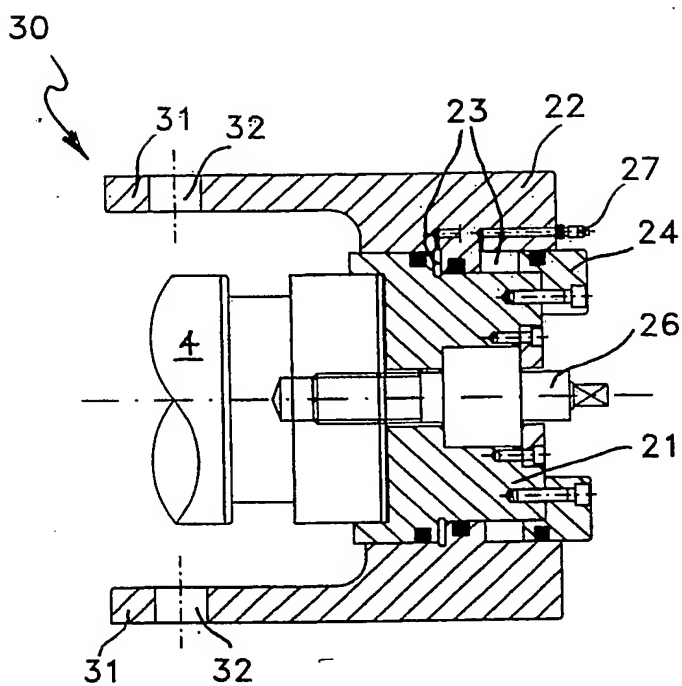


Fig. 5

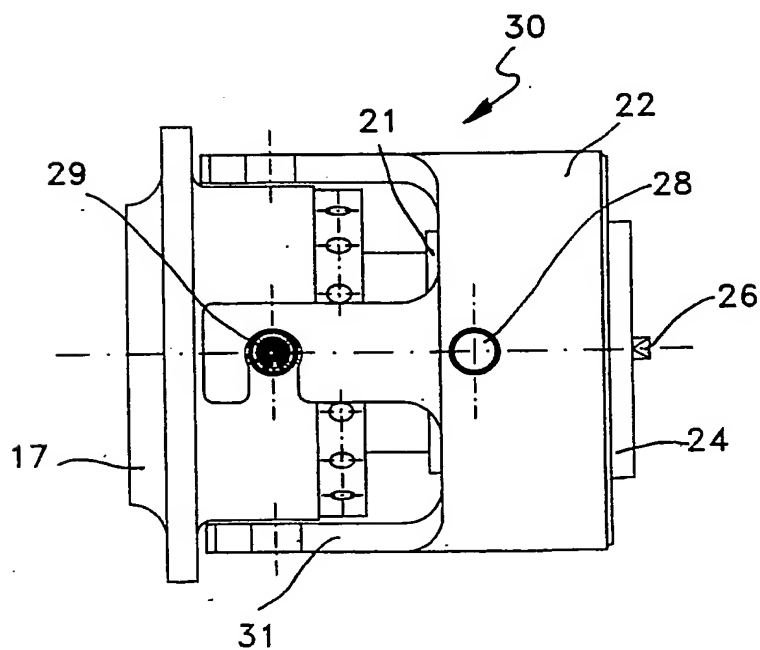


Fig. 6

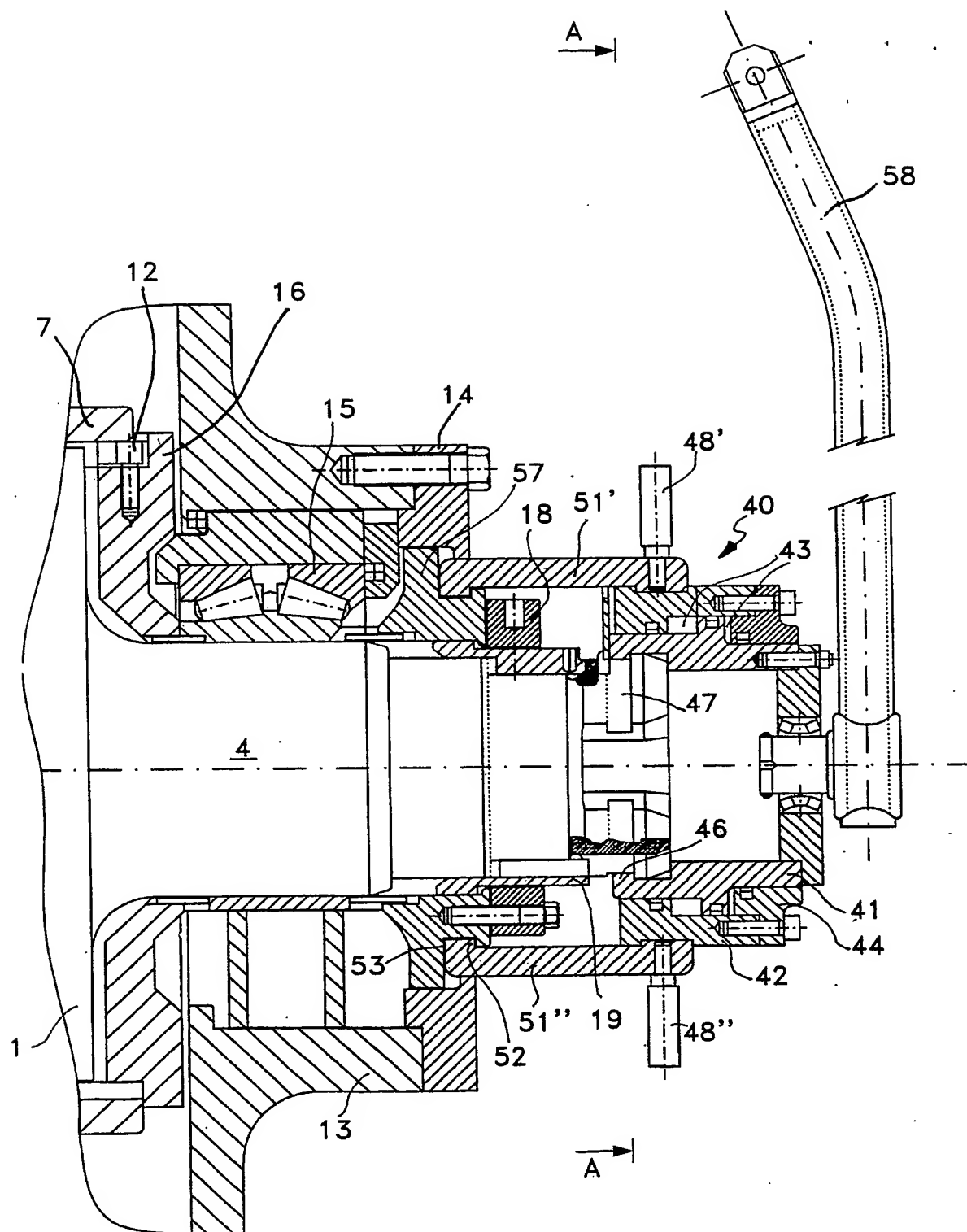


Fig. 7

Fig.8

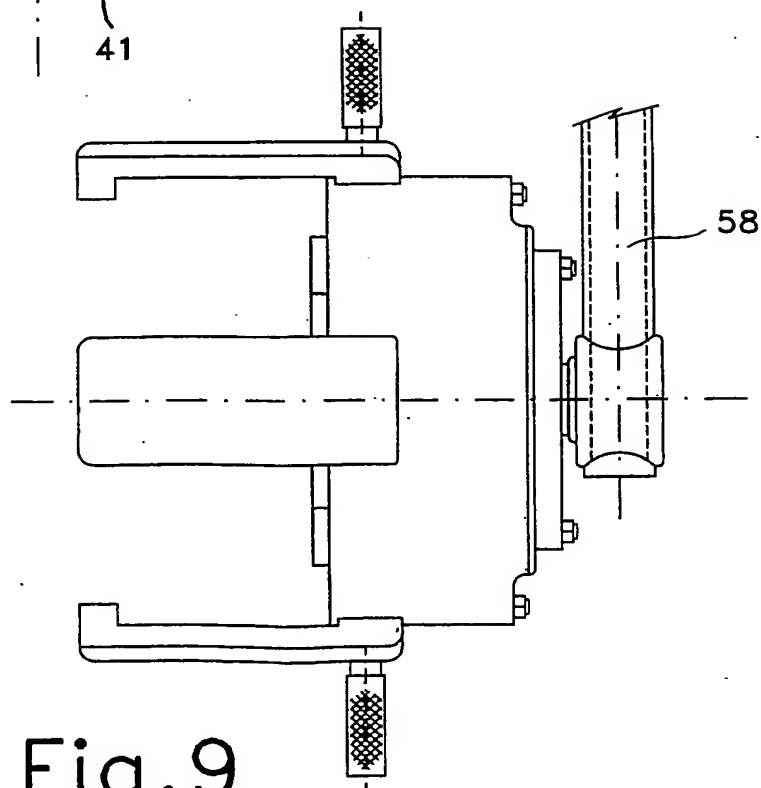
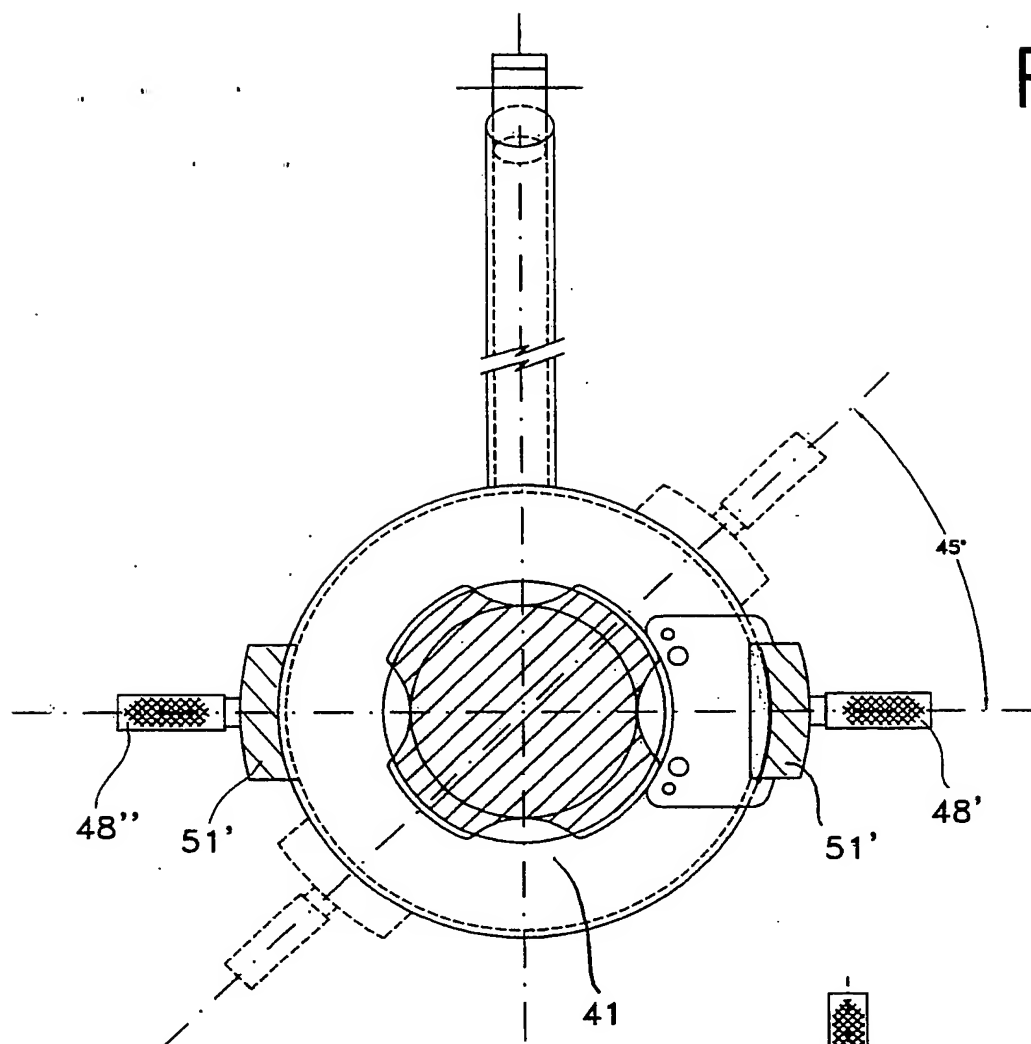


Fig.9

## INTERNATIONAL SEARCH REPORT

Int ional Application No

PCT/EP 02/09785

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 B21B31/08 B21B31/07 F16C13/02 F16C35/06

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B21B F16C B25B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, PAJ, WPI Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 01 21333 A (KUNZE VOLKER ; SMS DEMAG AG (DE); MÜLLER KARL FRIEDRICH (DE)) 29 March 2001 (2001-03-29) the whole document	1,4,5,9, 10
A	the whole document	7,8,11, 12
X	EP 1 072 333 A (MORGAN CONSTRUCTION CO) 31 January 2001 (2001-01-31) the whole document	1,4,5
A	the whole document	7-9,11, 12
A	US 3 799 636 A (DEIMANN F ET AL) 26 March 1974 (1974-03-26) the whole document	1,4,5
A	US 5 029 461 A (LAWRENCE GORDON D ET AL) 9 July 1991 (1991-07-09) the whole document	1,4
-/--		



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

## \* Special categories of cited documents :

- \*A\* document defining the general state of the art which is not considered to be of particular relevance
- \*E\* earlier document but published on or after the international filing date
- \*L\* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- \*O\* document referring to an oral disclosure, use, exhibition or other means
- \*P\* document published prior to the international filing date but later than the priority date claimed

\*T\* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

\*X\* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

\*Y\* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

\*G\* document member of the same patent family

Date of the actual completion of the international search

10 January 2003

Date of mailing of the international search report

17/01/2003

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

Rosenbaum, H

## INTERNATIONAL SEARCH REPORT

Int lional Application No

PCT/EP 02/09785

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 3 782 796 A (BOGHOSIAN H ET AL) 1 January 1974 (1974-01-01) the whole document ----	1, 4
A	US 3 080 199 A (RICKLEY SAMUEL S) 5 March 1963 (1963-03-05) the whole document ----	1
A	US 4 352 229 A (MOORE JR EDWARD A) 5 October 1982 (1982-10-05) the whole document ----	1
A	DE 91 14 718 U (SHEN FENG TOOLS) 16 January 1992 (1992-01-16) ----	
A	US 4 733 458 A (IRLE GERD ET AL) 29 March 1988 (1988-03-29) -----	

## INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/EP 02/09785

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
WO 0121333	A	29-03-2001	DE 19945070 A1	22-03-2001
			BR 0013865 A	14-05-2002
			CN 1374892 T	16-10-2002
			WO 0121333 A2	29-03-2001
			EP 1214158 A2	19-06-2002
			TW 473406 B	21-01-2002
EP 1072333	A	31-01-2001	AU 747718 B2	23-05-2002
			AU 4876700 A	01-02-2001
			BR 0003214 A	13-03-2001
			CN 1282646 A	07-02-2001
			EP 1072333 A2	31-01-2001
			JP 2001065583 A	16-03-2001
			PL 341751 A1	12-02-2001
			TW 469181 B	21-12-2001
			US 6415489 B1	09-07-2002
US 3799636	A	26-03-1974	DE 2006954 A1	09-09-1971
			GB 1342316 A	03-01-1974
			JP 51000645 B	09-01-1976
US 5029461	A	09-07-1991	CA 1311377 A1	15-12-1992
US 3782796	A	01-01-1974	BE 808044 A1	15-03-1974
			DE 2360188 A1	20-06-1974
			FR 2211073 A5	12-07-1974
			GB 1443348 A	21-07-1976
			IT 997684 B	30-12-1975
			JP 1199786 C	05-04-1984
			JP 49087934 A	22-08-1974
			JP 58033412 B	19-07-1983
			SE 402806 B	17-07-1978
US 3080199	A	05-03-1963	DE 1254108 B	16-11-1967
			FR 1321870 A	22-03-1963
			GB 932595 A	31-07-1963
US 4352229	A	05-10-1982	NONE	
DE 9114718	U	16-01-1992	DE 9114718 U1	16-01-1992
US 4733458	A	29-03-1988	DE 3605615 A1	27-08-1987
			AT 46942 T	15-10-1989
			AU 584269 B2	18-05-1989
			AU 6787187 A	27-08-1987
			BG 45859 A3	15-08-1989
			CS 8701141 A2	14-08-1989
			DD 254629 A5	02-03-1988
			DE 3760684 D1	09-11-1989
			EP 0233596 A2	26-08-1987
			GR 3000268 T3	15-03-1991
			HU 43379 A2	28-10-1987
			JP 2008647 C	11-01-1996
			JP 7045886 B	17-05-1995
			JP 62200020 A	03-09-1987
			KR 9102334 B1	20-04-1991
			PL 264163 A1	28-12-1987
			RO 102307 A2	14-10-1991



# INTERNATIONAL SEARCH REPORT

Information on patent family members

Int: International Application No

PCT/EP 02/09785

Patent document cited in search report ▶	Publication date	Patent family member(s)	Publication date
US 4733458	A	SU 1574183 A3	23-06-1990
		YU 24587 A1	30-04-1990
		ZA 8701166 A	28-10-1987
<hr/>			

Form PCT/ISA/210 (patent family annex) (July 1992)

**THIS PAGE BLANK (USPTO)**